

Work Order ID 60085

June 24, 2010 9:11:51 AM



Page 1

Item ID: D3259-7

Accept



Setup Start



Revision ID:

Item Name: Door

Stop



Start Date: 6/24/10 Start Qty: 2.00

Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 2.00

Customer:

Reference:

Run Start



Approvals: Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D3259	Rev B

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3259 i Dwg Rev: B i Prog Rev: B i 12-
Deburr if necessary

2004 .063

B10-608

②

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

B10-608

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

Sidouba

②

Work Order ID 60085



Page 2

June 24, 2010 9:11:51 AM

Item ID: D3259-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Door

Start Date: 6/24/10 Start Qty: 2.00



Cust Item ID:

Required Date: 7/02/10 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130 Chemical Conversion Coat per QSI005 4.1

0.00

=> MU

10/04/08



HandFinish

Memo

0.00

Hand Finishing

x2 9

140 QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

2 Bl 10-6-28

150 Identify as per dwg & Stock Location: 1847

0.00



Packaging

Memo

0.00

Packaging

Per 10/6/08 (2)

Work Order ID 60085

Page 3

June 24, 2010 9:11:52 AM

Item ID: D3259-7

Accept



Setup Start



Revision ID:

Stop



Item Name: Door

Start Date: 6/24/10

Start Qty: 2.00



Cust Item ID:

Required Date: 7/02/10

Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursTool ID Tool # Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/29

U 10/06/29

Picklist Print

June 24, 2010 9:11:50 AM

Page 1

Work Order ID: 60085

Parent Item: D3259-7

Parent Item Name: Door



Start Date: 6/24/10

Required Date: 7/02/10

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A New Issue 07-07-19 JLM Verified By:EC IPP REV
B:AS PER REV B 10-05-19 JLM VERIFIED BY:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3S.063		Purchased	No			110	sf	122.7000	1.388	2.922105			



2024-T3 .063 sheet



2010-6-28

Location

Loc Qty

Loc Code

MAT22

122.7

113866

18.5

114351

104.2

114351



60085

FIRST ARTICLE INSPECTION CHECKLIST

[illegible]

Measured by: <u>BR</u>	Audited by: <u>S</u>	Preliminary Approval:
Date: <u>10-6-98</u>	Date: <u>10/06/98</u>	Date:

Rev	Date	Change	Revised by	Approved
A	04.08.25	New Issue P/O D412-705-019	KJ/JLM	
B	10.06.07	Dwg Rev updated	KJ	

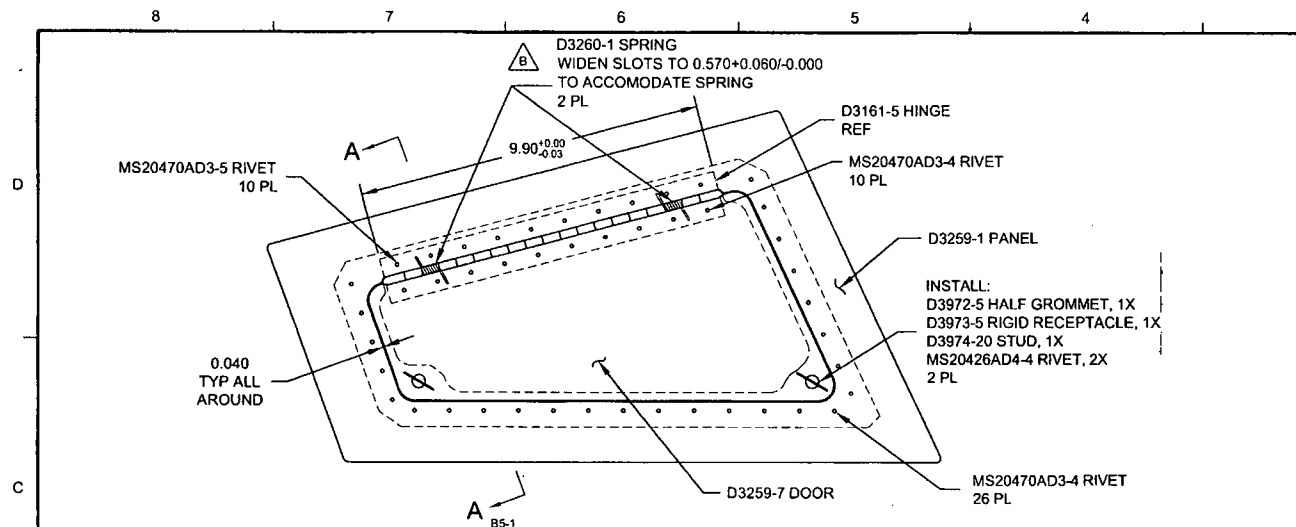
W/O:			WORK ORDER CHANGES					
DATE	STEP		PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

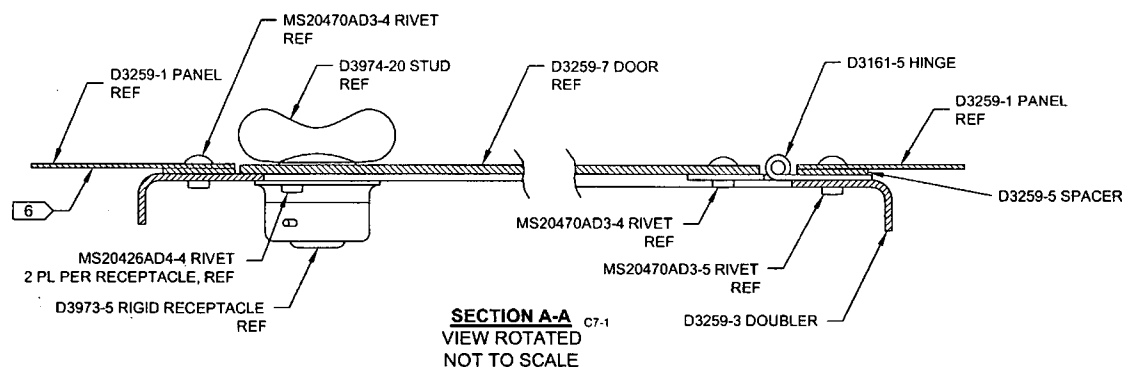
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:			WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP		Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
				Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-041	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-3	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF, DZUS
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET



D3259-041 ACCESS PANEL ASSEMBLY

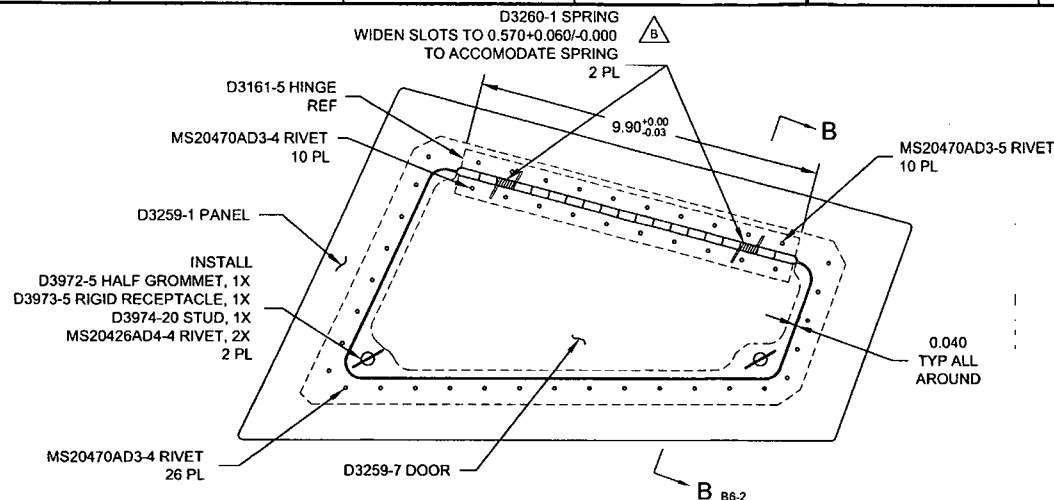
NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-041" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

RELEASED
2009-10-08

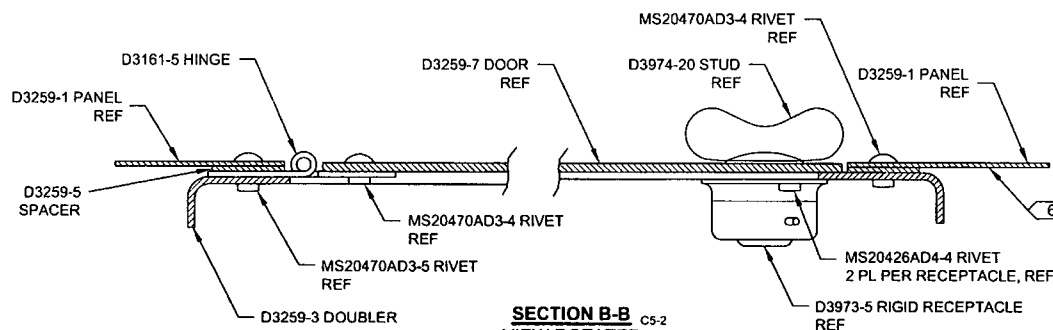
B	REFORMAT DWG, R0.25 WAS R0.18 (ZN B8-4, B1-5) -3F REDESIGN (SHT 6), WIDEN SLOTS (ZN D6-1, D5-2)		CP	09.08.12
A	NEW ISSUE		CP	04.02.25
REV.	DESCRIPTION		BY	DATE
DESIGN	RF	DART AEROSPACE LTD		
DRAWN		HAWKESBURY, ONTARIO, CANADA		
CHECKED		DRAWING NO.	REV. B	
MFG. APPR.		D3259	SHEET 1 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		ACCESS PANEL ASSEMBLY	NTS	
DATE	09.08.12	COPYRIGHT © 2004 BY DART AEROSPACE LTD		
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8 7 6 5 4 3 2 1



ITEM	QTY	PART NUMBER	DESCRIPTION
1	X	D3259-042	ACCESS PANEL ASSEMBLY
2	1	D3161-5	HINGE
3	1	D3259-1	PANEL
4	1	D3259-4	DOUBLER
5	1	D3259-5	SPACER
6	1	D3259-7	DOOR
7	2	D3260-1	SPRING
8	2	D3972-5	GROMMET, HALF
9	2	D3973-5	RECEPTACLE, RIGID, DZUS
10	2	D3974-20	STUD, WING HEAD, 5/16 DZUS
11	36	MS20470AD3-4	RIVET
12	10	MS20470AD3-5	RIVET
13	4	MS20426AD4-4	RIVET

60085



SECTION B-B
VIEW ROTATED

D3259-042 ACCESS PANEL ASSEMBLY

NOTES:

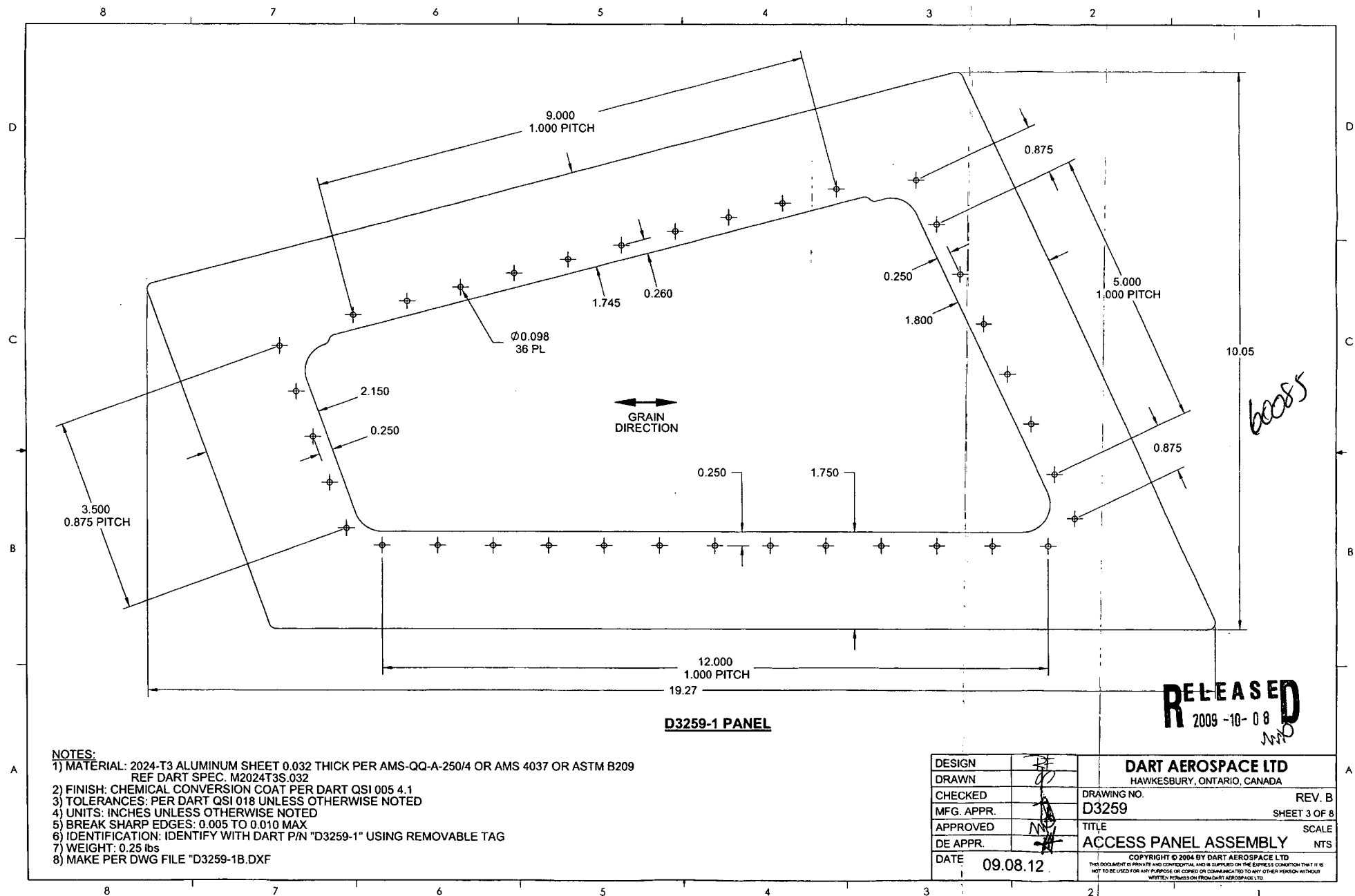
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: NONE
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D3259-042" AND B/N "BXXXXX" USING FINE POINT PERMANENT MARKER
- 7) WEIGHT: 1.2 lbs

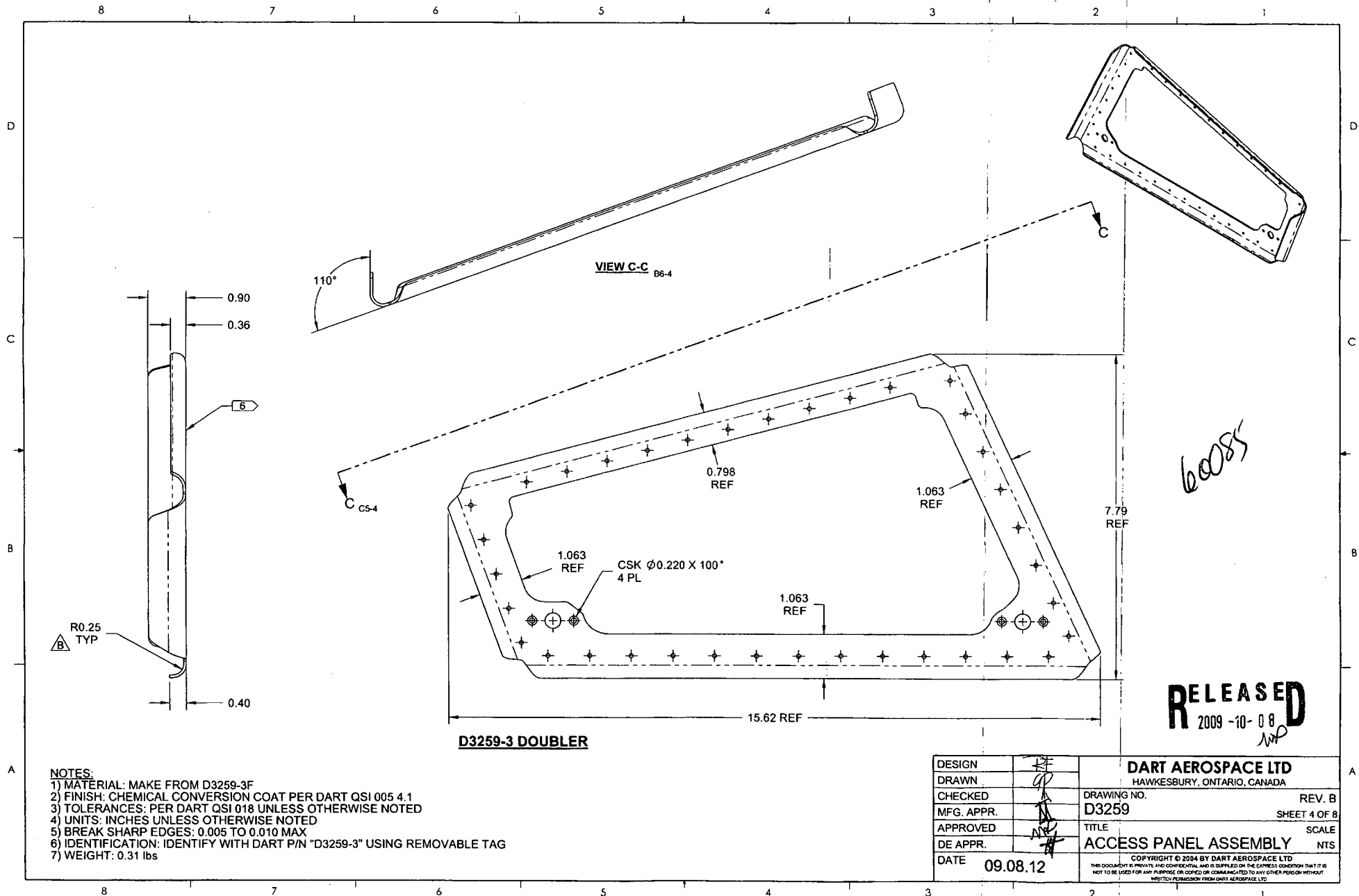
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2009-10-08

MP

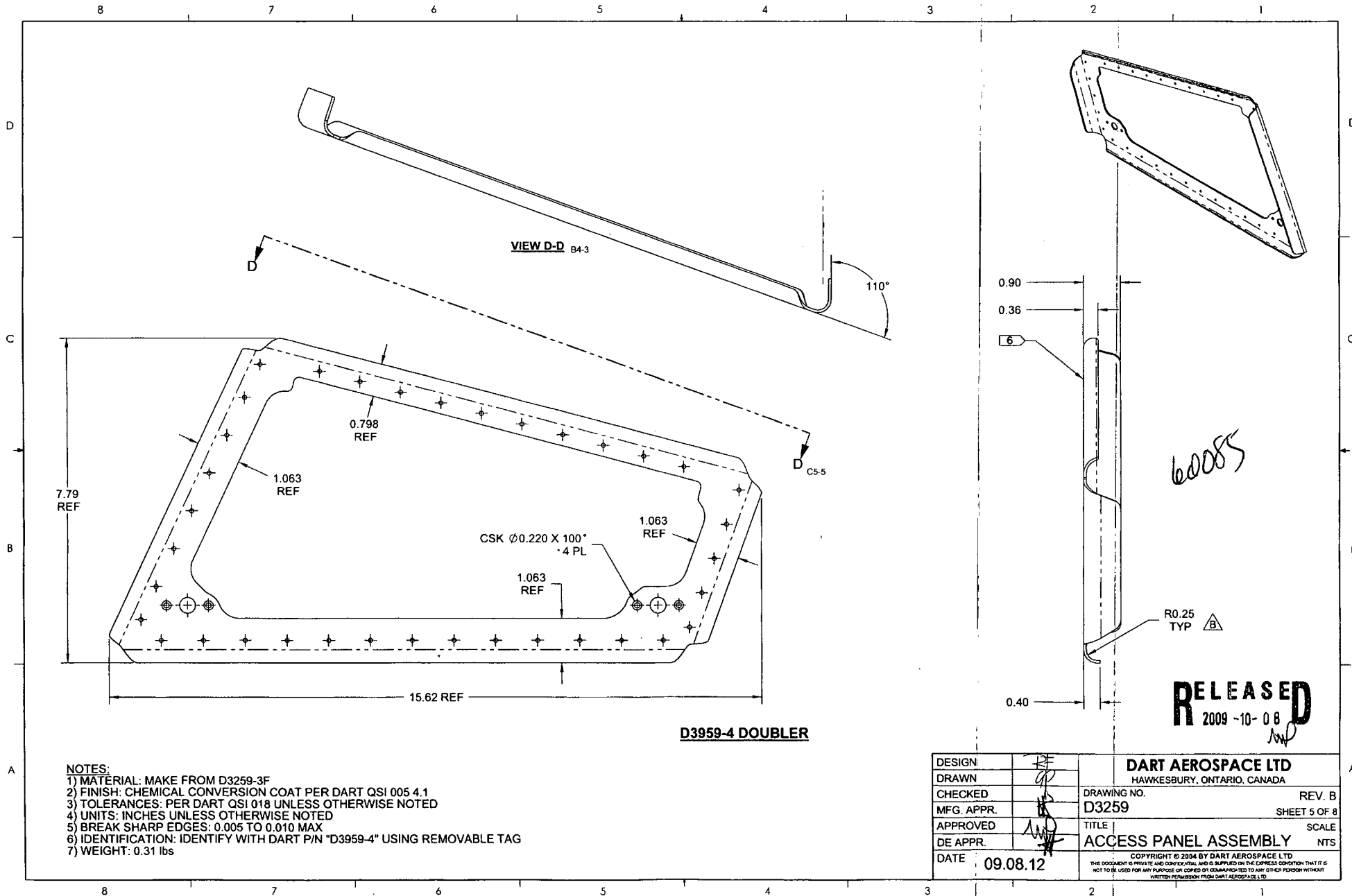
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MFG. APPR.		D3259	SHEET 2 OF 8
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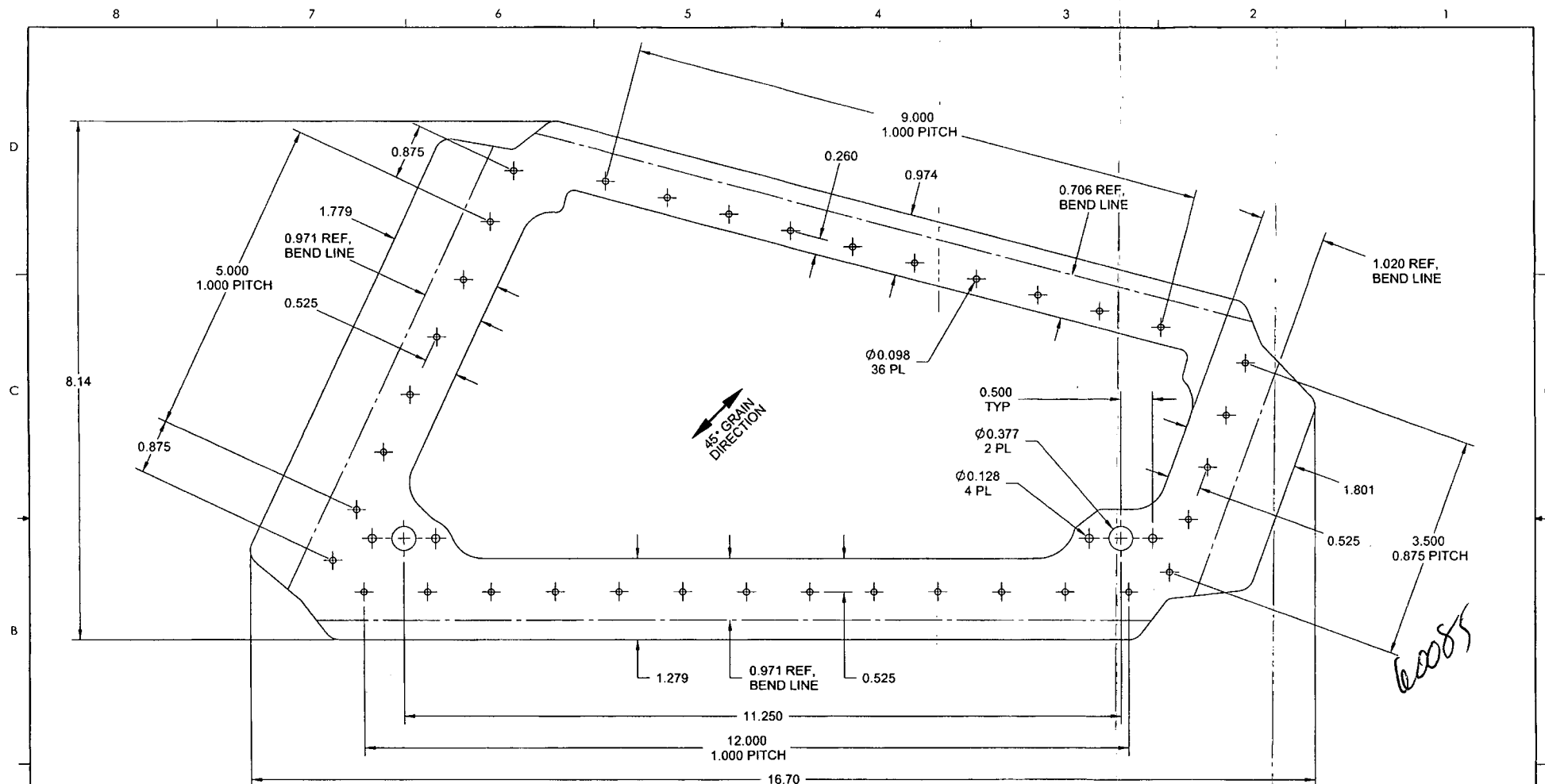
8 7 6 5 4 3 2 1





DESIGN	REF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	GP		
CHECKED	AS	DRAWING NO. D3259	REV. B
MFG. APPR.	AS		SHEET 4 OF 8
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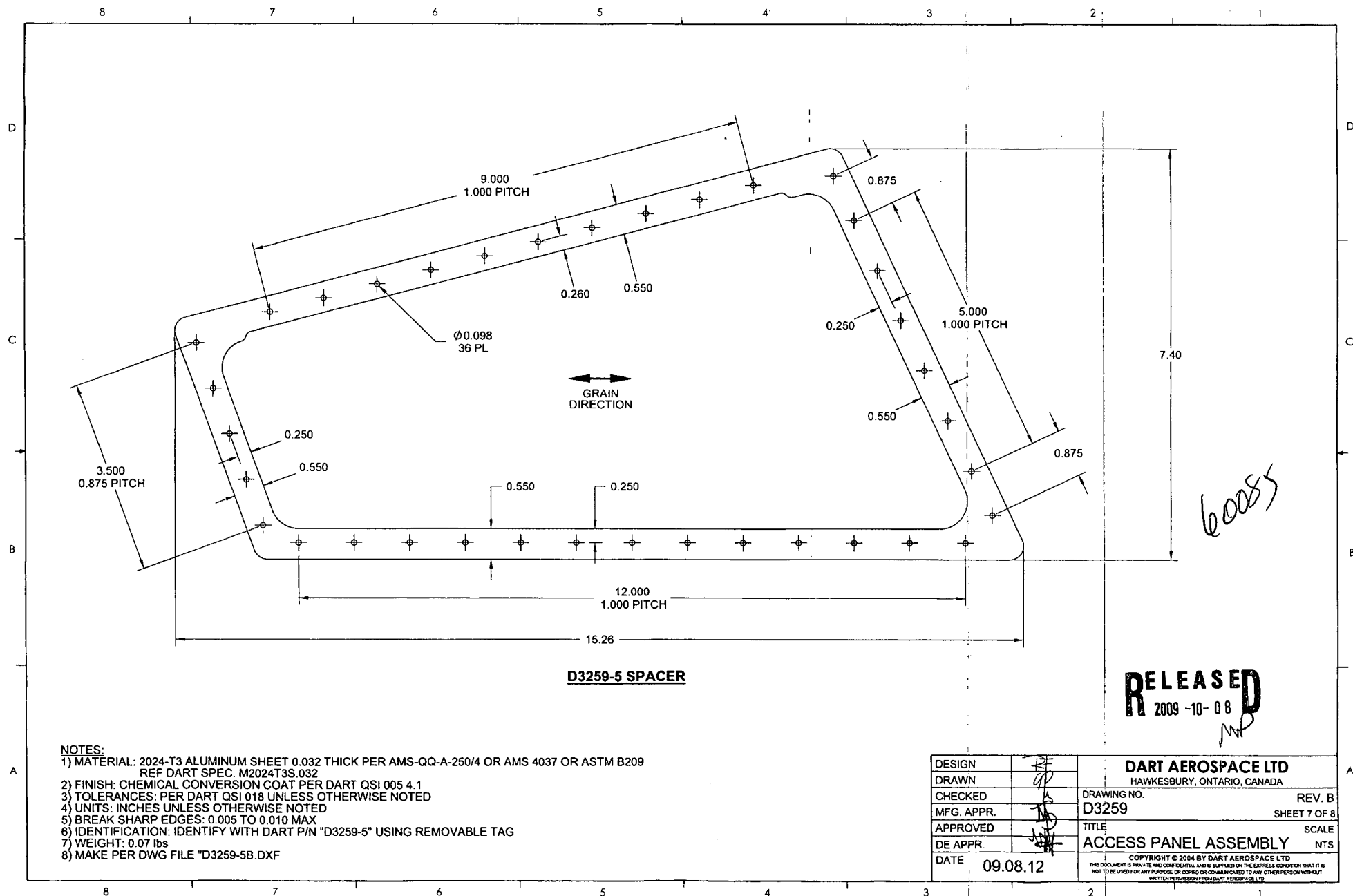
D3259-3F DOUBLER

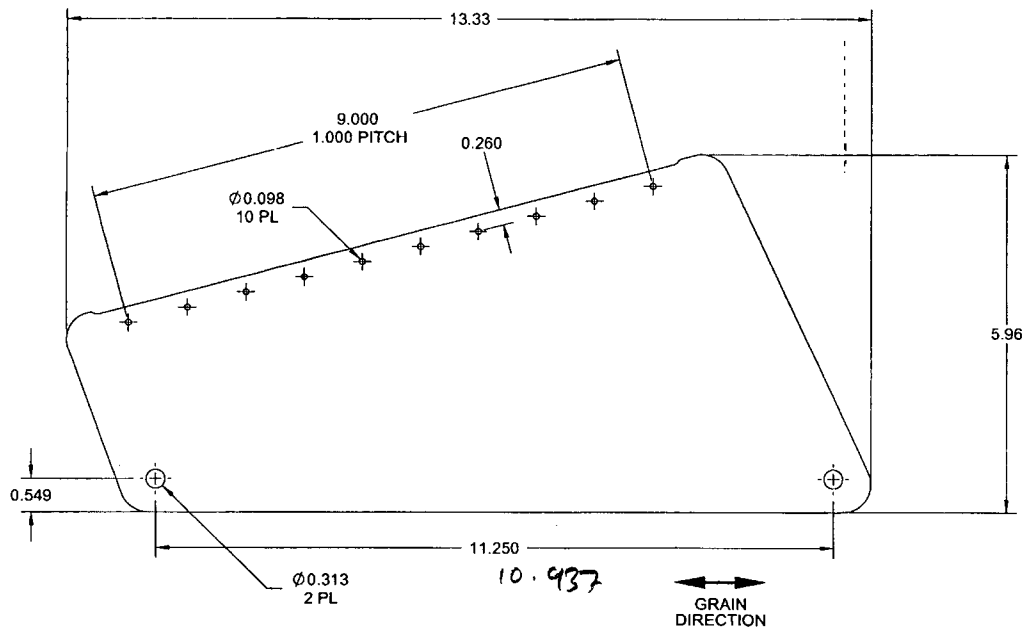
NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-3F" USING REMOVABLE TAG
- 7) WEIGHT: 0.31 lbs
- 8) MAKE PER DWG FILE "D3259-3FB.DXF"

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MFG. APPR.		D3259	SHEET 6 OF 8
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D3259-7 DOOR

NOTES:

- 1) MATERIAL: 2024-T3 ALUMINUM SHEET 0.063 THICK PER AMS-QQ-A-250/4 OR AMS 4037 OR ASTM B209
REF DART SPEC. M2024T3S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3259-7" USING REMOVABLE TAG
- 7) WEIGHT: 0.35 lbs
- 8) MAKE PER DWG FILE "D3259-7B.DXF"

DESIGN		DART AEROSPACE LTD	
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